

FLight Test Aug 14

Work Order ID 72666

Thursday, August 04, 2011 2:42:24 PM



Item ID: D4281-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 8/4/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-08-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4281

B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

3-OPEN HOLES ON DRILL PRESS AS PER DWG

11-8-10

(6)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11-8-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
130 Mill Conv Conventional Milling Machine	Manufacture as per dwg Memo 1- Face to size as per dwg 2- deburr	0.00 0.00							
140 QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00							

u195

ent 11/08/11

6

ent 11/08/11

6

Pro →

Suloolu

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/08/17	120 + 140	Remove step 120 AND change Step 140 to a QCE	MA	11.08.17	MA	MA	S u/ce/ce	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Thursday, August 04, 2011 2:42:24 PM



Page 3

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Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 8/4/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6 of 11 8/15

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

POWDER COAT:

Start Time:

Oven Temperature:

Finish Time:

*10:50
320°F
11:20*

6x Ø m-l 11/08/15

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 of 11 8/15

M 118439

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Thursday, August 04, 2011 2:42:24 PM



Accept

**Setup Start**

Stop

**Cust Item ID:**

1 2 3 4 5 6 7 8 9 10 11 12

[illegible]

Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

Identify as per dwg & Stock Location: 139C



Packaging

Memo

0.00

0.00

Packaging

190

QC21- Final Inspection - Work Order Release



QC


Memo

0.00

0.00

Quality Control

11/6/6 S/60

_____ n 18/18 

11-08-14
(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Thursday, August 04, 2011 2:42:30 PM

Page 1

Work Order ID: 72666

Parent Item: D4281-3

Parent Item Name: Spacer



Start Date: 8/4/2011

Required Date: 8/8/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B0.750X02.00
0

Purchased

No

f

22.5010

0.698947

4.



6061-T6 Bar .750 x 2.00



B11-8-10

Location

Loc Qty

Loc Code

MAT003

22.501

100742

3.271

111448

19.23

111448

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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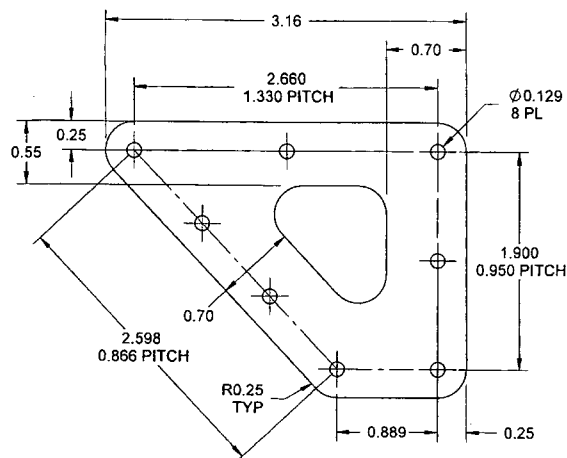
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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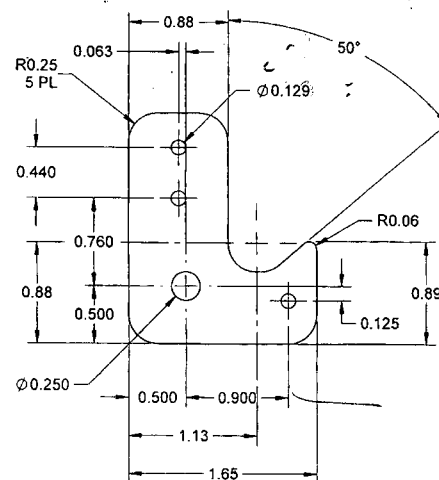
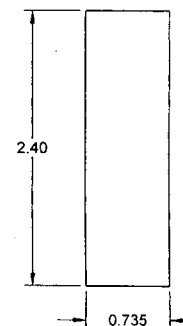
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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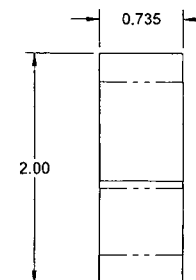
NOTE: Date & initial all entries



D4281-1 SPACER



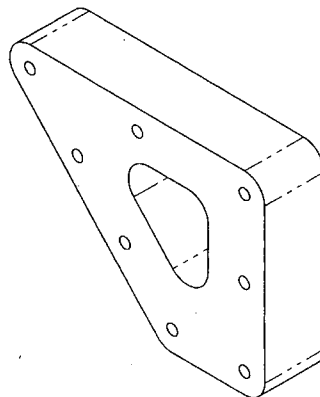
D4281-3 SPACER



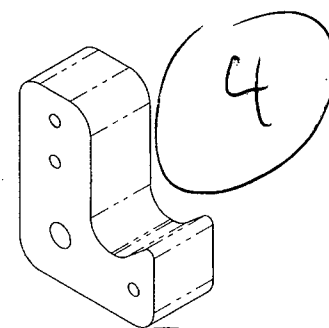
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4281	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACER	NTS
DATE	11.07.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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72666

RELEASED
2011-07-28
[Signature]



D4281-1 SPACER



D4281-3 SPACER

RELEASED
2011-07-28
JW

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.34 lbs
-3: 0.15 lbs

B	ADDED SHT 2, ADDED -3	AJS	11.07.04
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION		BY DATE
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. B
MFG' APPR.	E	D4281	SHEET 1 OF 2
APPROVED	140	TITLE	SCALE
DE APPR.	#	SPACER	NTS
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